

CHEMICAL COMPOSITION

| C | Cr | Mo | W | Co | V |
|------|------|------|------|----|------|
| 0.97 | 3.00 | 8.20 | 1.40 | - | 1.75 |

STANDARDS

- USA: AISI M7
- Europe: HS 2-9-2
- Germany: 1.3348
- France: AFNOR Z100DCWV9.4.2.2
- Sweden: SS2782
- Japan: JIS SKH58

DELIVERY HARDNESS

- Typical soft annealed hardness is 250 HB

DESCRIPTION

M7 is a molybdenum-alloyed grade with some vanadium in order to increase the wear resistance.

APPLICATIONS

- Twist drills
- Taps
- Reamers
- Rolls
- End mills

FORM SUPPLIED

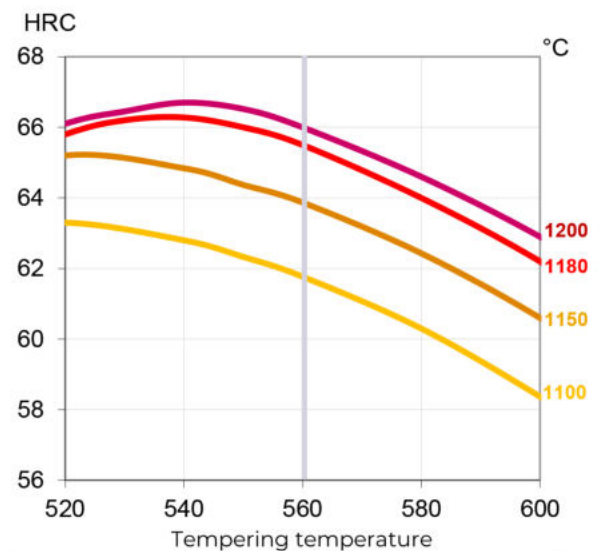
- Square bars
- Round bars
- Flat bars

Available surface conditions: ground, peeled, hot rolled.

HEAT TREATMENT

- Soft annealing in a protective atmosphere at 850-900°C for 3 hours, followed by slow cooling 10°C per hour down to 700°C, then air cooling.
- Stress-relieving at 600°C to 700°C for approximately 2 hours, slow cooling down to 500°C.
- Hardening in a protective atmosphere with pre-heating in 2 steps at 450-500°C and 850-900°C and austenitising at a temperature suitable for chosen working hardness.
- 2 tempers at 560°C are recommended with at least 1 hour holding time each time.

GUIDELINES FOR HARDENING



Hardness after hardening, quenching and tempering 2x1 hour

| Tool | Hardening | Tempering |
|---------------------------|-------------|-----------|
| Single-edge cutting tools | 1200°C | 550-570°C |
| Multi-edge cutting tools | 1150-1200°C | 550-570°C |
| Cold work tools | 1100-1150°C | 550-570°C |

PROCESSING

M7 can be worked as follows:

- machining (grinding, turning, milling)
- polishing
- hot forming
- electrical discharge machining
- welding (special procedure including preheating and filler materials of base material composition).

GRINDING

During grinding, local heating of the surface, which can alter the temper, must be avoided. Grinding wheel manufacturers can provide advice on the choice of grinding wheels.

SURFACE TREATMENT

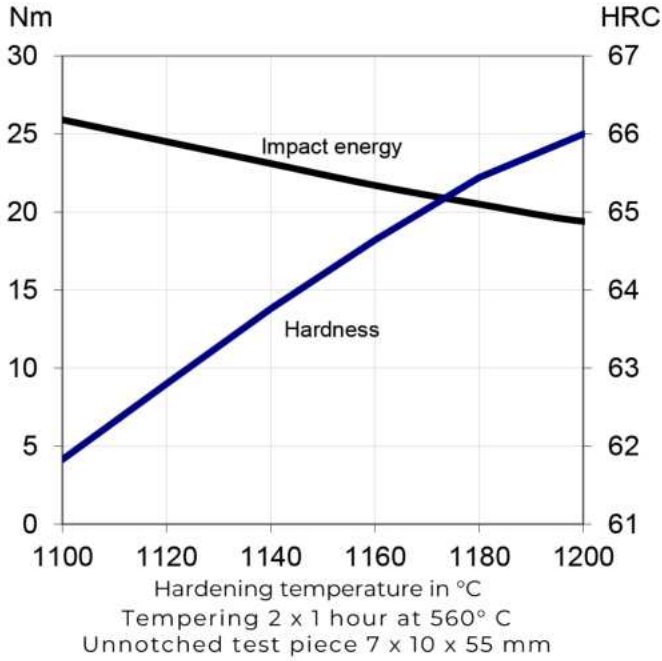
The steel grade is a perfect substrate material for PVD coating. If nitriding is requested, a small diffusion zone is recommended but avoid compound and oxidized layers.

PROPERTIES

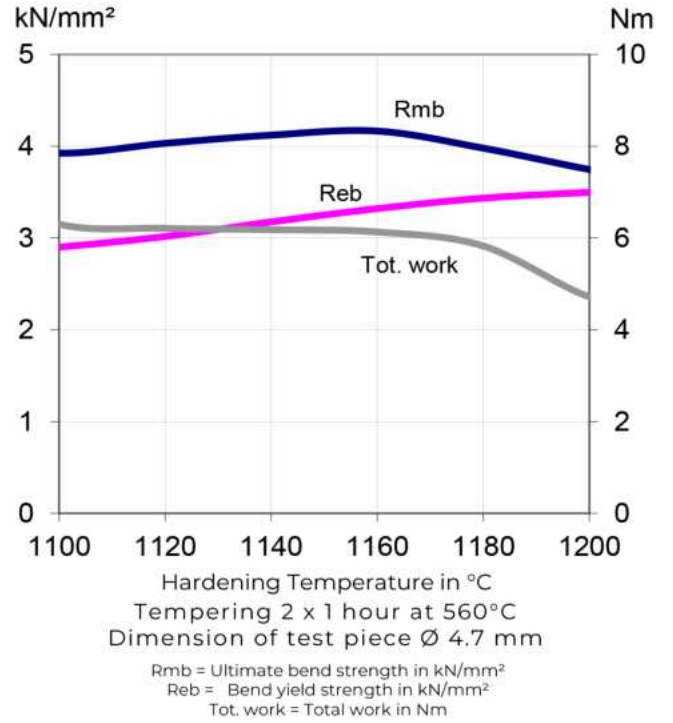
PHYSICAL PROPERTIES

| Temperature | 20°C |
|----------------------------|------|
| Density g /cm ³ | 7.9 |

IMPACT TOUGHNESS



4-POINT BEND STRENGTH



COMPARATIVE PROPERTIES

